

# Work Order ID 64381

December 3, 2010 10:08:20 AM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 12/03/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/12/03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2273	D								
D350-604-041	A								
DSI9470	A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

Sub 11.6

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13059  
Description: D350-604-041 Rear locker extender.  
Supplier: Delastek.  
Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 115814

CL 10/12/03 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64381**

December 3, 2010 10:08:20 AM



Page 2

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 12/03/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



Packaging

Receive & Inspect for Damage & Mat'l Certs  
Packaging

0.00

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

*12/17/10* (1)

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Check hole locations to template. DT 8824 Check process sheet and audit.

*8/16/11**40*

140



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

*11/18* *sf*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64381**

December 3, 2010 10:08:20 AM



Page 3

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 12/03/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Subtotal

②

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: 52PPP Rev: 9

11/1/10 sf

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/2010

ME  
11-01-19

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 3, 2010 10:08:19 AM

Page 1

Work Order ID: 64381

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 12/03/10

Required Date: 1/04/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

2600-6

Purchased

No

110

Each

109.0000

4

4



Camlock Stud



CL10/12/03

Location

Loc Qty

Loc Code

ST381

109

114238

4

115814

36

115987

69

4

D2268

Manufactured

No

140

Each

16.0000

1

1



Decal



11/1/125

Location

Loc Qty

Loc Code

ST010

16

60213

1

62243

5

64072

10

1

D2269

Manufactured

No

140

Each

11.0000

1

1



Decal



11/1/18

Location

Loc Qty

Loc Code

ST010

11

62244

1

63338

10

1

D350-604-041P

Purchased

No

120

Each

0.0000

1

1



Rear Locker Extender



B264381 11/1/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

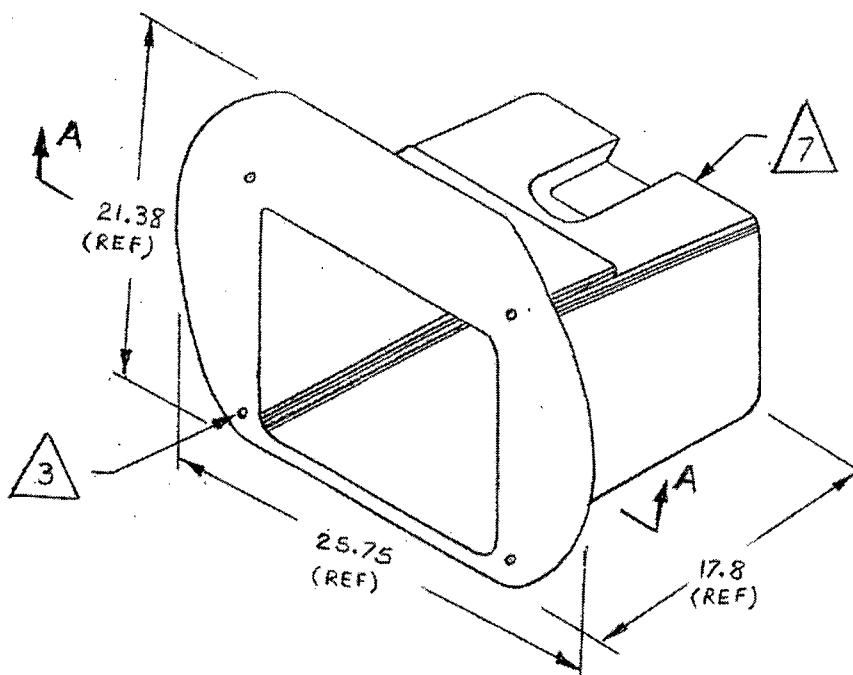




DESIGN	JB	DRAWN BY	JP	DART AEROSPACE LTD	REV. D
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	AS	DRAWING NO. D2273	SHEET 1 OF 1
DATE	02.04.01	TITLE	350 REAR LOCKER EXTENDER	SCALE	NTS
B	96.05.27	RE-DRAWN			
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING			
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH			

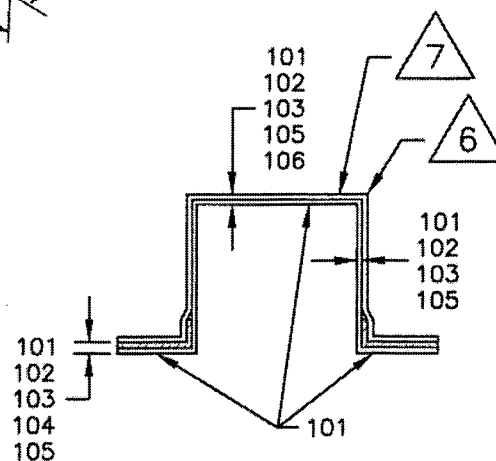
RELEASED  
02.04.03

CL10112103  
W10: 64381



**NOTES:**

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO  $\phi 0.257$  (4 PLACES).
- 4) MATERIALS:  
RESIN: DERAKANE 470-36/411/510A40  
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS  
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:  
101-WHITE GLOSS GELCOAT # GEL 944W005.  
102-9oz ALL OVER.  
103-18oz ALL OVER.  
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.  
105-9oz ALL OVER.  
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

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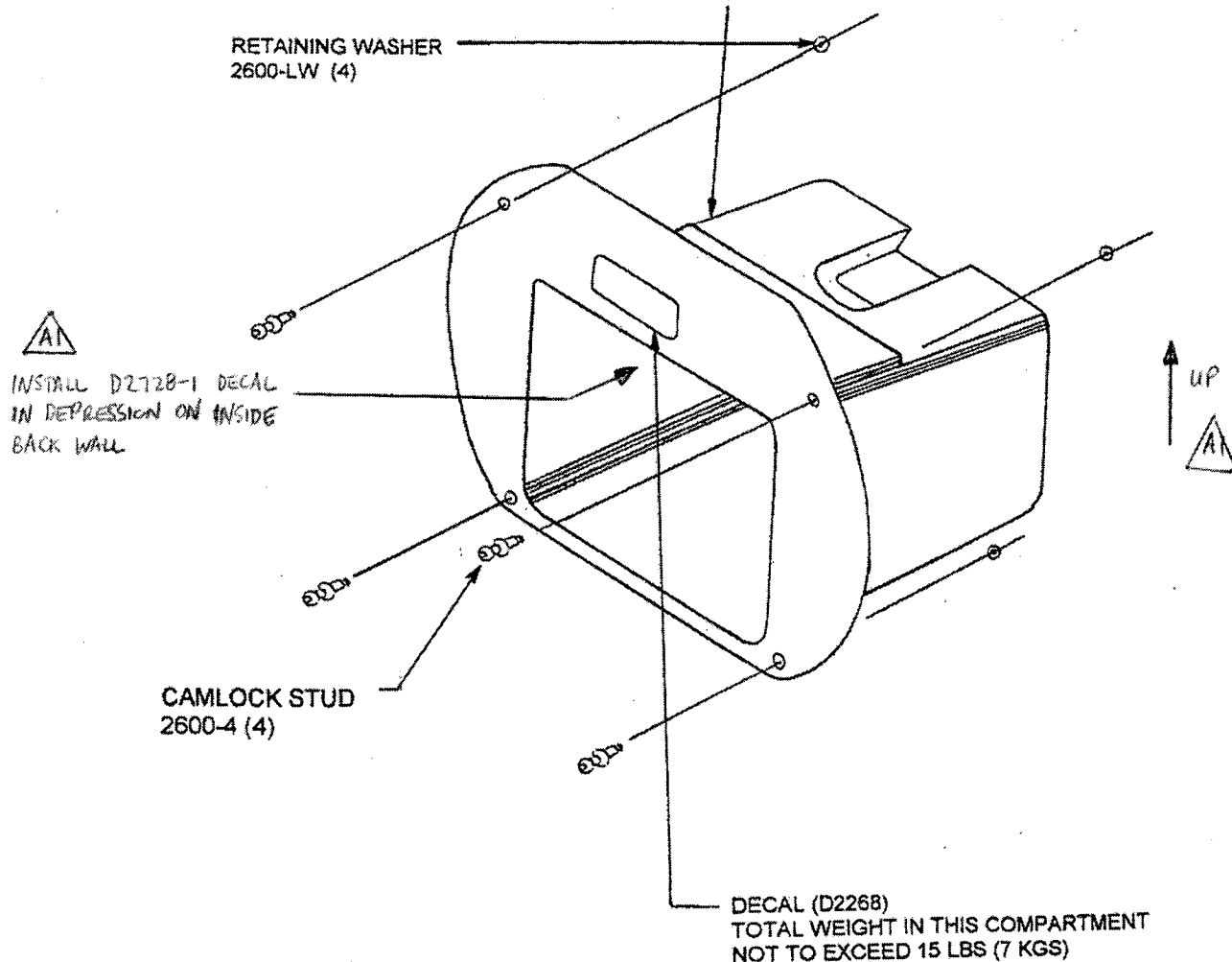
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DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
A1	RF 02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE REAR LOCKER EXTENDER (D2273)	

RELEASED  
02.04.03

W10: 64381



### D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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# **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4  
REF FAA STC: SR00463NY

## **PURPOSE:**

The 2600-4 Camloc Studs may be too short for some installations.

## **CHANGE:**

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

QTY	PART NUMBER	DESCRIPTION
-041		
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASS'Y

## **IS:**

4	2600-6	CAMLOC STUD
---	--------	-------------

## **WAS:**

4	2600-4	CAMLOC STUD
---	--------	-------------

W10: 64381

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.07.01  
CERT. NO.: SH90-4  
ISSUE NO.: 3

A	NEW ISSUE, NCR 09-046	CP	09.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN	92	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	97		
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	NIA	DSI 9470	SHEET 1 OF 1
APPROVED	W	TITLE	SCALE
DE APPR.	W	CAMLOC CHANGE	NTS
DATE	09.07.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO13059

Purchase Order Date 12/03/10

PO Print Date 12/03/10

Page Number 1 of 2

Order From :

VU-DEL003

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 123

GRAND-MERE, QC G9T 5K7  
CA

Contact Name

Vendor Phone 819 533 5788

Vendor Fax 819 533 3494

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
6/10/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D350-604-041P	Rear Locker Extender	1/04/11 Yes	1.00 Each	Purolator ground	\$330.0000	\$330.00
		Special Inst:	AS PER DWG D2273 REV.D B64378				
2	D350-604-041P	Rear Locker Extender	1/04/11 Yes	1.00 Each	Purolator ground	\$330.0000	\$330.00
		Special Inst:	AS ABOVE B64379				
3	D350-604-041P	Rear Locker Extender	1/04/11 Yes	1.00 Each	Purolator ground	\$330.0000	\$330.00
		Special Inst:	AS ABOVE B64380				
4	D350-604-041P	Rear Locker Extender	1/04/11 Yes	1.00 Each	Purolator ground	\$330.0000	\$330.00

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 12/03/10



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	36658
Customer #	DART US

Telephone: (819) 533-5788  
Warehouse: MAIN

**Bill to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lacelle

<b>Ship via</b>		<b>F.O.B.</b>		<b>Terms</b>		<b>Salesperson</b>	
PURO GROUND		Point de départ		Net 30 days USA		Claude Lessard, ext. 233	
<b>Ship date</b>	<b>Order Date</b>	<b>Our PO #</b>	<b>Order by</b>	<b>Your PO #</b>	<b>GST/PST #</b>		
14/01/2011	03/12/2010	16222	Chantal Lavoie	PO13059			
<b>Order Qty</b>	<b>B.O. Qty</b>	<b>Current Ship.</b>	<b>Item #</b>	<b>Item Description</b>			
1	0	1	DKC134-0003	Line #4 Rear Locker Extender D350-604-041P B64381 Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> B64381  <u>No. lot</u> 30655  <i>Suloris</i>			
U de M : Each							

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by: \_\_\_\_\_


Quality department

AQ-357



Date: Mercredi, 2010-12-08 16:25:37  
 Auteur: Pascal Carignan

**Feuille de Procédé**

<b>Client</b> :	DART US DART AEROSPACE LTD	<b>Nom Dessin</b> :	REAR LOCKER EXTENDER
<b>Numéro Job</b> :	30655	<b>Numéro Article</b> :	DKC134-0003
<b>Numéro Soumission</b> :	3482	<b>Numéro Dessin</b> :	D350-604-041 & D2273
<b>Numéro B.A.</b> :		<b>Projet Numéro</b> :	DK-362
<b>Cette fois</b> :	2010-12-08	<b>Révision dessin</b> :	A & D
<b>Prsht Rev.</b> :	NC	<b>Matériel</b> :	Derakane 470-36/411/510
<b>Prem. fois</b> :	- -	<b>Date Dûe</b> :	2010-12-15
<b>Job précédente</b> :	30654	<b>Qté:</b>	1 Udm: UNITE
<b>Écrit par</b> :			
<b>Vérifié &amp; Approuvé par</b> :			
<b>Commentaires</b> :	N° de pièce Laminée Dart Aerospace: D2273 N° de pièce Assemblage Dart Aerospace: D350-604-041		

B64381

Process Sheet Rév.: 01 Mise en page selon nouvelle forme.  
 Déplacer cette séq. 12 en avant de la séq. 6. Ajouter sablage dans  
 séq. Trimage.

**Produit additionnel**

Numéro Job:




# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: 13/12/10 Sceau: 

2.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)  
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-29020-1

3.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)  
 Catalyst N° DDM-9 N° de Lot: 1-22176-1

4.0	AC0747	Acetone
-----	--------	---------



Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

5.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 10/12/10 Sceau:  

ate: Mercredi, 2010-12-08 16:25:37  
tilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 30655

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

6.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du matériel selon IF134-0003 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% d'acétone.

Date: 13/12/10

Sceau:



7.0

GEL COAT

Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1

Date: 13/12/10

Sceau:



8.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-29179-1

9.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

10.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-28776-2

11.0

AMB0213

WR1850 Roving 18oz x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot: 1-22302-1

12.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 22%

Température: 70.5°F

Heure: \_\_\_\_\_

Date: Mercredi, 2010-12-08 16:25:37  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30655

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.: Machine ou Opération: Description :

Quantité: 1

Date: 14/12/10

Sceau:



13.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total: 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-29325-1

14.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

15.0 FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon IF134-0003 si applicable.

Quantité: 1

Date: 16-12-10

Sceau:



16.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Quantité: 1

Date: 15/12/10

Sceau:



17.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1

Date: 17-12-10

Sceau:



18.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total: 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-28961-2



Date: Mercredi, 2010-12-08 16:25:37  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30655

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
19.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase


Commentair Qty.: 0.0670 UNITE(s)/Unit Total: 0.0670 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-28382-1

20.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1 Date: 11 jan 11 Sceau:  N° fiche de Mélange: N/A

21.0	AAC1607	Camlock Stud 2600-4 (or Monadnock 1126000-4)
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Commentair Qty.: 4 UNITE(s)/Unit Total: 4 UNITE(s)  
Camlock Stud 2600-4 (or Monadnock 1126000-4) N° de Lot: 1-28576-1

22.0	AAC0682	Washer 2600-LW (1127700)
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Commentair Qty.: 4 UNITE(s)/Unit Total: 4 UNITE(s)  
Washer 2600-LW (1127700) N° de Lot: 1-6687-1

23.0	ASSEMBLAGE	Assemblage mécanique
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasker la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1 Date: 14/01/11 Sceau: 

24.0	IDENTIFICATION	Identification à encre indélébile
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005

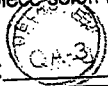
Quantité: 1 Date: 14-01-11 Sceau: L.S.

25.0	INSPEC FINAL	Inspection finale
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Quantité: 1 Date: 14 jan. 11 Sceau: 

Date: Mercredi, 2010-12-08 16:25:37  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30655

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

26.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité: 1

Date: 14 Jan 11

Sceau: L.B

*fab. 14 Jan 2011*

*Job 30655*